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K6A 1K7
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0006140

647.3704
Job Sheet 184042



Part No: 647.3704

Job Qty: 1 ea

Part Name: 204,205,212,214 Cable Cutter System, High



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/2/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 647.3700 REV.A IPP REV:A 12.10.26 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.26 as per ecr 14-214 DD VERF:JLM IPP REV:C AS PER REV NC3 15.03.18 JLM VERIFIED BY:DD IPP REV:D 18.01.19 AS PER DWG REV.A DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/23/18	11/23/18	0.00	0.00	Start Up Stores/Pkg-2	JAS 6	OCT 29 2018
110	Packaging	1 pcs	11/23/18	11/23/18	0.00	0.00	Packaging1-1	6 DAS	NOV 20 2018
120	QC	1 pcs	11/23/18	11/23/18	0.00	0.00	QC4	9-89 46	NOV 20 2018
130	Packaging	1 pcs	11/23/18	11/23/18	0.00	0.00	Packaging3-1	9-89 46	NOV 20 2018
135	DC	1 pcs	11/23/18	11/23/18	0.00	0.00	DC	9-89	NOV 20 2018
140	QC21-FG	1 Ea	11/23/18	11/23/18	0.00	0.00	QC21	9-89	NOV 20 2018

Part Op 130 - Identify and pack for shipping as per PPP 647.3704
Descriptions: 135 - Photocopy bluefile & type labels per PPP 647.3704

DAS NOV 20 2018
21
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	5119525
601.2045	RTV (LOCTITE 598)	1 Ea (1 ea)	90-Start up Operation	5052768
601.3073	Connector p/n 082-4440	1 Ea (1 ea)	90-Start up Operation	F163232
601.3083	Adhesive Rubber Seal	2 Ea (2 ea)	90-Start up Operation	5113236
647.3802	212 Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5128005
647.3804	204,205,212,214,412 Lower Cutter Assembly High	1 Ea (1 ea)	90-Start up Operation	2116672
647.3903	Deflector Assembly	1 Ea (1 ea)	90-Start up Operation	3119404
647.4010	Wiper Deflector RH	1 Ea (1 ea)	90-Start up Operation	F158452
647.4011	Wiper Deflector LH	1 Ea (1 ea)	90-Start up Operation	5062598
647.4110	Doubler	1 Ea (1 ea)	90-Start up Operation	5004370
647.4111	Doubler	1 Ea (1 ea)	90-Start up Operation	F161210
647.4112	Clip	1 Ea (1 ea)	90-Start up Operation	5059110
647.4113	Clip	1 Ea (1 ea)	90-Start up Operation	F163489
647.4114	Shim	2 Ea (2 ea)	90-Start up Operation	5026930
647.4115	Shim	2 Ea (2 ea)	90-Start up Operation	F165550X1
647.4116	Shim	1 Ea (1 ea)	90-Start up Operation	F158848
647.4210	Bracket LH	1 Ea (1 ea)	90-Start up Operation	F161755
647.4211	Bracket RH	1 Ea (1 ea)	90-Start up Operation	F161784
647.4212	Plate	1 Ea (1 ea)	90-Start up Operation	F150884
647.4310	LH Lower Strut	1 Ea (1 ea)	90-Start up Operation	5060797
647.4311	RH Lower Strut	1 Ea (1 ea)	90-Start up Operation	5107320

Exp 4/19
Exp 6/19

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐	AGAINST DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
Date : _____		MRB (QSI042) Approval			
		DART AEROSPACE Part: 647.3704 Job No: 184042 Serial No/Batch: S122472 Revision: A Inspector: _____ Exp Date: _____ Instructions: FAA STC SR022891A 17/03/07 to STC LCA RI			
		Completed By			
		Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval	
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

647.4312	LH Upper Strut	1 Ea (1 ea)	90-Start up Operation	F162442
647.4313	RH Upper Strut	1 Ea (1 ea)	90-Start up Operation	F158436
647.4410	Rail	1 Ea (1 ea)	90-Start up Operation	F155358
AN3-11A	Bolt	8 Ea (8 ea)	90-Start up Operation	5098034
AN3-4A	Bolt	3 Ea (3 ea)	90-Start up Operation	5060063
AN3C10A	Bolt	2 Ea (2 ea)	90-Start up Operation	5019323
CCR264SS-3-03	Cherry Rivet	16 Ea (16 ea)	90-Start up Operation	5099729
CCR264SS3-04	Rivet	12 Ea (12 ea)	90-Start up Operation	5108574
CR3212-4-2	Cherry Rivet	11 Ea (11 ea)	90-Start up Operation	5102069
CR3212-4-3	Cherry Rivet	17 Ea (17 ea)	90-Start up Operation	5053949
CR3212-4-04	Cherry Rivet	7 Ea (7 ea)	90-Start up Operation	5045669
CR3213-4-2	Cherry Rivet	31 Ea (31 ea)	90-Start up Operation	5019424
CR3213-4-3	Rivet, Cherry	24 Ea (24 ea)	90-Start up Operation	5098033
CR3213-4-4	Rivet, Cherry	16 Ea (16 ea)	90-Start up Operation	5049830
CR3213-4-5-05	Rivet	28 Ea (28 ea)	90-Start up Operation	5019315
CR3213-4-8	Rivet	4 Ea (4 ea)	90-Start up Operation	5067267
MS21042-08	Use Ms21042L08	18 Ea (18 ea)	90-Start up Operation	5100409
MS21042-3	Nut	79 Ea (79 ea)	90-Start up Operation	5108577
MS21047-3	Nut Plate	4 Ea (4 ea)	90-Start up Operation	5103943
MS21047L06	Nut Plate	6 Ea (6 ea)	90-Start up Operation	FM138408
MS21047L08	Nut Plate	6 Ea (6 ea)	90-Start up Operation	5016504x4. 5107432x2
MS21071L3	Anchor Nut	4 pcs (4 ea)	90-Start up Operation	FM137680.0
MS24694-C53	Screw	8 Ea (8 ea)	90-Start up Operation	FM137951-7
MS24694-S49	Screw	1 Ea (1 ea)	90-Start up Operation	FM129702
MS27039-08-08	Screw	16 Ea (16 ea)	90-Start up Operation	5053952
MS27039-08-11	Screw	2 Ea (2 ea)	90-Start up Operation	FM138336-10
MS27039-1-07	Screw	12 Ea (12 ea)	90-Start up Operation	5079112
MS27039-1-09	Screw	14 Ea (14 ea)	90-Start up Operation	5017101
MS27039-1-10	Screw	42 Ea (42 ea)	90-Start up Operation	5071834
NAS1149F0332P	Washer	157 Ea (157 ea)	90-Start up Operation	5109991
NAS1149FN832P	Washer	34 Ea (34 ea)	90-Start up Operation	5100408

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.1012	1	14	0
	601.2045	1	20	0
	601.3073	1	1	0
	601.3083	1	4	0
	647.3802	1	0	0
	647.3804	1	0	0
	647.3903	1	0	0
	647.4010	1	8	0
	647.4011	1	6	0
	647.4110	1	2	0
	647.4111	1	9	0
	647.4112	1	10	0
	647.4113	1	4	0
	647.4114	2	5	0
	647.4115	2	5	0
	647.4116	1	15	0
	647.4210	1	7	0
	647.4211	1	7	0
	647.4212	1	2	0
	647.4310	1	10	0
	647.4311	1	10	0
	647.4312	1	3	0
	647.4313	1	3	0
	647.4410	1	2	0
	AN3-11A	8	219	0
	AN3-4A	3	431	0
	AN3C10A	2	12	0
	CCR264SS-3-03	16	602	0
	CCR264SS3-04	12	82	0
	CR3212-4-2	11	89	0
	CR3212-4-3	17	107	0
	CR3212-4-4	7	290	0
	CR3213-4-2	31	75	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

CR3213-4-3	24	288	0
CR3213-4-4	16	687	0
CR3213-4-5	28	180	0
CR3213-4-8	4	116	0
MS21042-08	18	1	0
MS21042-3	79	426	0
MS21047-3	4	536	0
MS21047L06	6	61	0
MS21047L08	6	53	0
MS21071L3	4	49	0
MS24694-C53	8	35	0
MS24694-S49	1	153	0
MS27039-08-08	16	48	0
MS27039-08-11	2	1,283	0
MS27039-1-07	12	225	0
MS27039-1-09	14	94	0
MS27039-1-10	42	214	0
NAS1149F0332P	157	3,011	0
NAS1149FN832P	34	3,526	0

Part Specifications

Specifications could not be found.

Plex 10/2/18 8:44 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

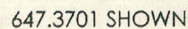
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

REFERENCE ONLY

6 VENDOR: MCMaster-CARR
VENDOR P/N: 86715K27
60A DUROMETER



					56	647.5701					4
		A/R	A/R	A/R	A/R	55	601.2045	RTV		LOCITE 598	5
		A/R	A/R	A/R	A/R	54	601.1012	SEALANT		PR-1425 CLASS B	5
		2	2	2	2	53	601.3083	ADHESIVE RUBBER SEAL		MIL-R-3065	6
		4	4	4	4	52	601.2957	NUTPLATE		MS210713	
		4	4	4	4	51	600.0795	NUTPLATE		MS21047-3	
		6	6	6	6	50	601.3066	NUTPLATE		MS21047L08	
		6	6	6		49	601.3065			MS21047L08	
		18	18	18	18	48	601.2973	LOCKNUT		MS21042-08	
		79	79	79	79	47	601.2943	LOCKNUT		MS21042-3	
		4	4	4	4	46	601.2364	CERRY RIVET		CR3213-4-8	
		28	28	42	42	45	601.1183	CERRY RIVET		CR3213-4-5	
		16	16	19	19	44	601.1915	CERRY RIVET		CR3213-4-4	
		24	24	32	32	43	601.0790	CERRY RIVET		CR3213-4-3	
	.3704.	.3703.	.3702.	.3701	FIND	PART #		DESCRIPTION		MAT'L	SPEC.

	31	31	13	43	42	601.1039	CHERRY RIVET	CR3213-4-2	
	16	16	16	16	41	601.2207	NUTPLATE RIVET	CR3213-4-2	
	12	12	12	12	40	601.2491	NUTPLATE RIVET	CR3213-4-2	
	7	7	4	4	39	601.1066	CHERRY RIVET	CR3212-4-4	
	17	17	17	17	38	601.1065	CHERRY RIVET	CR3212-4-3	
	11	11	12	12	37	601.1604	CHERRY RIVET	CR3212-4-2	
					36		DELETED		
	2	2	2	2	35	601.1874	BOLT	AN3C10A	
	8	8	8	8	34	601.2826	BOLT	AN3-11A	
	3	3	3	3	33	601.2823	BOLT	AN3-4A	
	1	1	1		32	601.3073		082-4440	3 2
	8	8	8	8	31	601.2419	SCREW	MS24694C53	
	1	1	1	1	30	601.3070	SCREW	MS24694-549	
	2	2	2	2	29	601.2893	SCREW	MS27039-0811	
	14	14	14	14	28	601.3069	SCREW	MS27039-1-09	
	16	16	16	16	27	601.2263	SCREW	MS27039-0808	
	42	42	42	42	26	601.1365	SCREW	MS27039-1-10	
	12	12	12	12	25	601.2198	SCREW	MS27039-1-07	
	157	157	157	157	24	601.1607	WASHER	NAS1149F0332P	
	34	34	34	34	23	601.2764	WASHER	NAS1149F08332P	
	1	1	1	1	22	647.4313	RH UPPER STRUT		
	1	1	1	1	21	647.4312	LH UPPER STRUT		
	1	1	1	1	20	647.4310	LH LOWER STRUT		
	1	1	1	1	19	647.4311	RH LOWER STRUT		
	1	1			18	647.4212			
	1	1	1	1	17	647.4211	BRACKET RH		
	1	1	1	1	16	647.4210	BRACKET LH		
	1	1	1	1	15	647.4116	SHIM		
	2	2	2	2	14	647.4115	SHIM		
	2	2	2	2	13	647.4114	SHIM		
	1	1	1	1	12	647.4113	CLIP		
	1	1	1	1	11	647.4112	CLIP		
	1	1	1	1	10	647.4111	DOUBLER		
	1	1	1	1	9	647.4110	DOUBLER		
	1	1	1	1	8	647.4011	WIPER DEFLECTOR LH		
	1	1	1	1	7	647.4010	WIPER DEFLECTOR RH		
	1	1	1	1	6	647.3903	DEFLECTOR ASSEMBLY		
	1	1	1	1	5	647.4410	RAIL		
	1		1		4	647.3804	LOWER CUTTER ASSY HIGH		
		1		1	3	647.3803	LOWER CUTTER ASSY LOW		
	1	1			2	647.3802	212 UPPER CUTTER ASSY		
			1	1	1	647.3801	412 UPPER CUTTER ASSY		
						647.3704	204, 205, 212, 214 CABLE CUTTERS KIT HIGH		
						647.3703	204, 205, 212, 214 CABLE CUTTERS KIT LOW		
						647.3702	412 CABLE CUTTERS KIT HIGH		
						647.3701	412 CABLE CUTTERS KIT LOW		
	3704	3703	3702	3701	FIND	PART #	DESCRIPTION	MAT'L	SPEC.

QTY		PARTS LIST	
NEXT ASSY (S)		ORIGINAL DATE (MFG. EX. 1A) 09-29-09 DRAWN BY J. JACKSON CHECKED D. BARKER DESIGNED BY APPROVAL 09-21-09 CONTRACT NO.	
		3030 ENTERPRISE CT., SUITE A VISTA, CA, 92081-8347 (760) 724-3300 DART KEROGRAPH APICAL INDUSTRIES, INC. dino DART & KEROGRAPH 4102 CABLE CUTTERS KIT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE FRACTIONS DECIMALS ±.01 ANGLES ± .5°		SHEET NO. DWG. NO. REV. A B 07M26 647.3700 SCALE NONE 1 SHEET 1 OF 5	

REFERENCE ONLY

REFERENCE ONLY